

Work Order ID 82717

82717

Page 1

Thursday, April 05, 2012 12:56:26 PM

Item ID: D3768-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Front Inboard Leg

Start Date: 4/5/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 4/13/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Run Start ***NR1***

Approvals: Process Plan: *12*

Date: *12-04-15* Tooling:

Date:

Stop ***NR2***

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3768	Rev A								

100

0.00

100

Small Fab

Small Fab

Memo

0.00

Small Fab

I-CUT TUBE TO LENGH AS PER DWG D37682-DRILL TUBE USING
DT9044 AND AS PER DWG D37683-DEBURR

4 *0* *FF 12-04-16*

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

Size 1/16

(40)

120

Chemical Conversion Coat per QSI005 4.1

0.00

120

HandFinish

Memo

0.00

Hand Finishing

(4)

HG 12-4-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Thursday, April 05, 2012 12:56:26 PM

Item ID: D3768-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Front Inboard Leg
 Start Date: 4/5/2012 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 4/13/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Powdercoat Powder Coating	Fire Red(Ref:4.3.5.10) per QSI005 4.3 Memo START TIME: 12:45 FINISH TIME: 1:15	0.00 0.00				4X	Ø		M-1 12/04/19
140 *140* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				4X	Ø		12/04/19
150 *150* Packaging Packaging	Identify as per dwg & Stock Location: 251 Memo	0.00 0.00				4X	Ø		12/4/23

W/O:		WORK ORDER CHANGES					
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Work Order ID 82717***82717***

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Thursday, April 05, 2012 12:56:26 PM

Item ID: D3768-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Front Inboard Leg
Start Date: 4/5/2012 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 4/13/2012 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

12/4/23

12-04-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

Thursday, April 05, 2012 12:56:30 PM

Page 1

Work Order ID: 82717

82717

Parent Item: D3768-1

D3768-1

Parent Item Name: Front Inboard Leg

Start Date: 4/5/2012

Required Date: 4/13/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 08-06-18 rev.A as per dwg DD verified by:EC
IPP Rev:B 08-08-25 Rev B Added Drilling tooling JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6T1.000W065

Purchased

No

100

f

83.2542

0.8542

3.596632

M6061T6T1 000W065

**

FF 12-04-16

6061T6.RD TUBE 1.00 x .065w

Location

Loc Qty

Loc Code

MAT015

83.2542

114089

0.3114

116720

2

117983

80.9428

3.596632

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RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 82717

pl 1204-5



D3768-1 FRONT INBOARD LEG



D3768-3 FRONT OUTBOARD LEG, LH



D3768-4 FRONT OUTBOARD LEG, RH

RELEASED
08-06-13

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING (1.00" OD X 0.065" WALL) PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 (REF. DART SPEC. M6061T6T1.00W.065)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "FIRE RED" (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.19 lbs

A		NEW ISSUE		HS	08.06.04
REV.		DESCRIPTION		BY	DATE
DESIGN		HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
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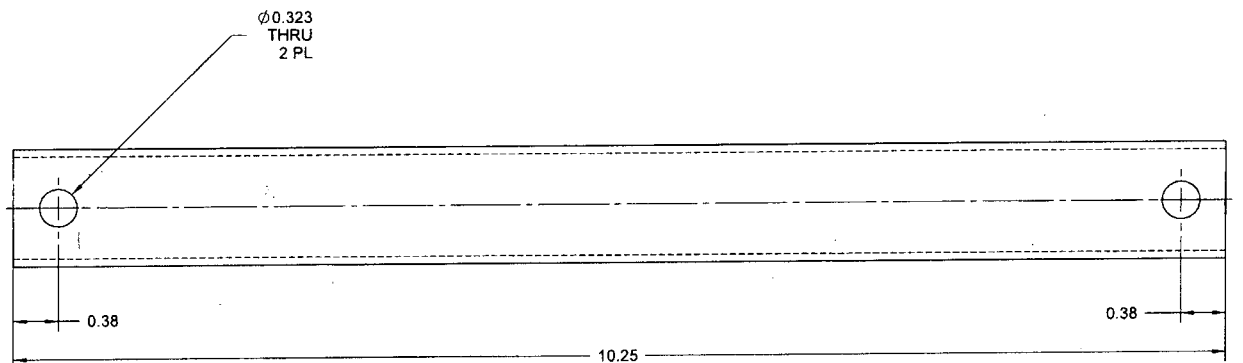
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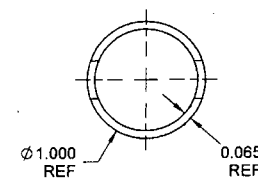
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D3768-1 FRONT INBOARD LEG



RELEASED
08.06.12/118

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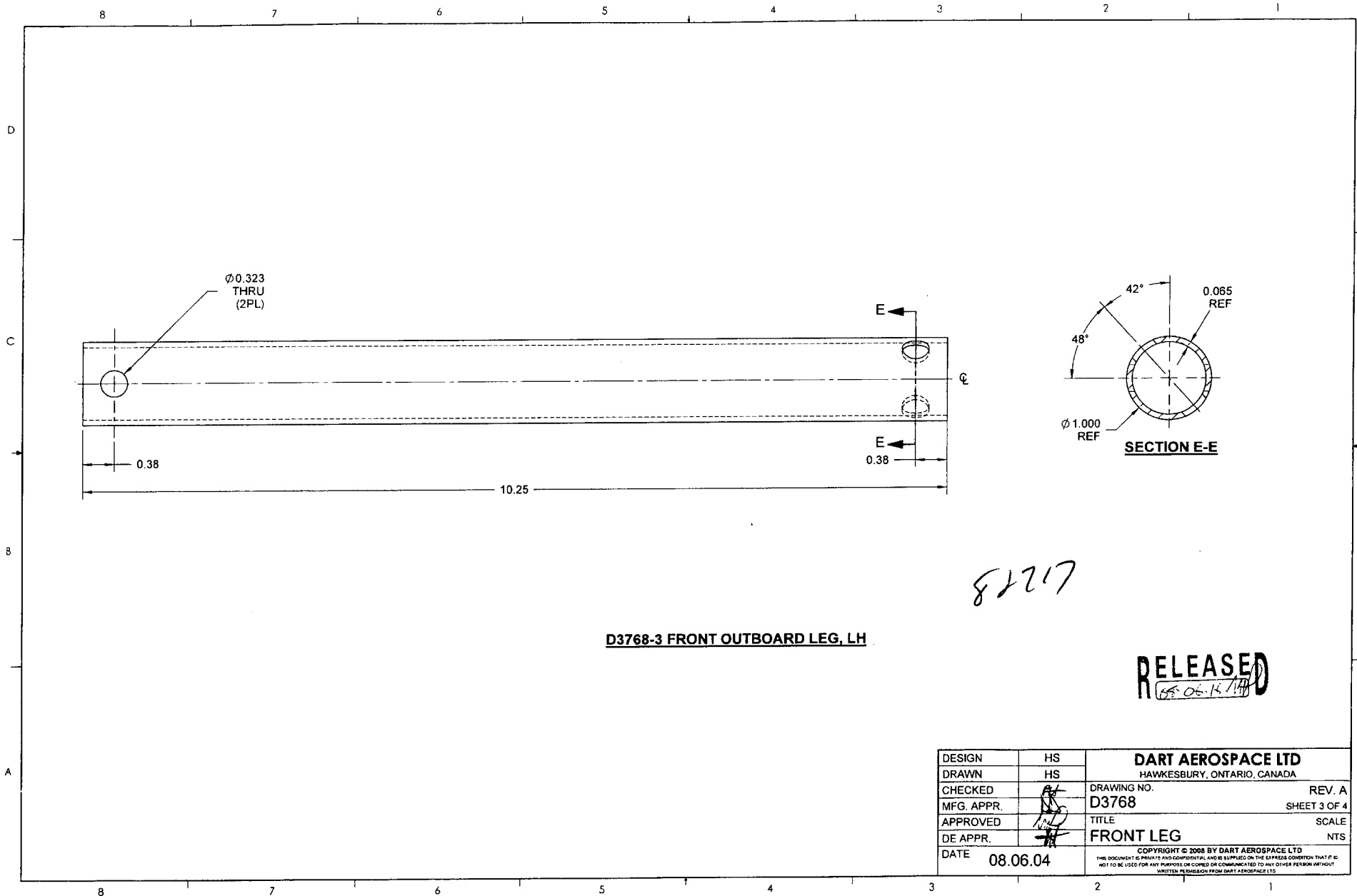
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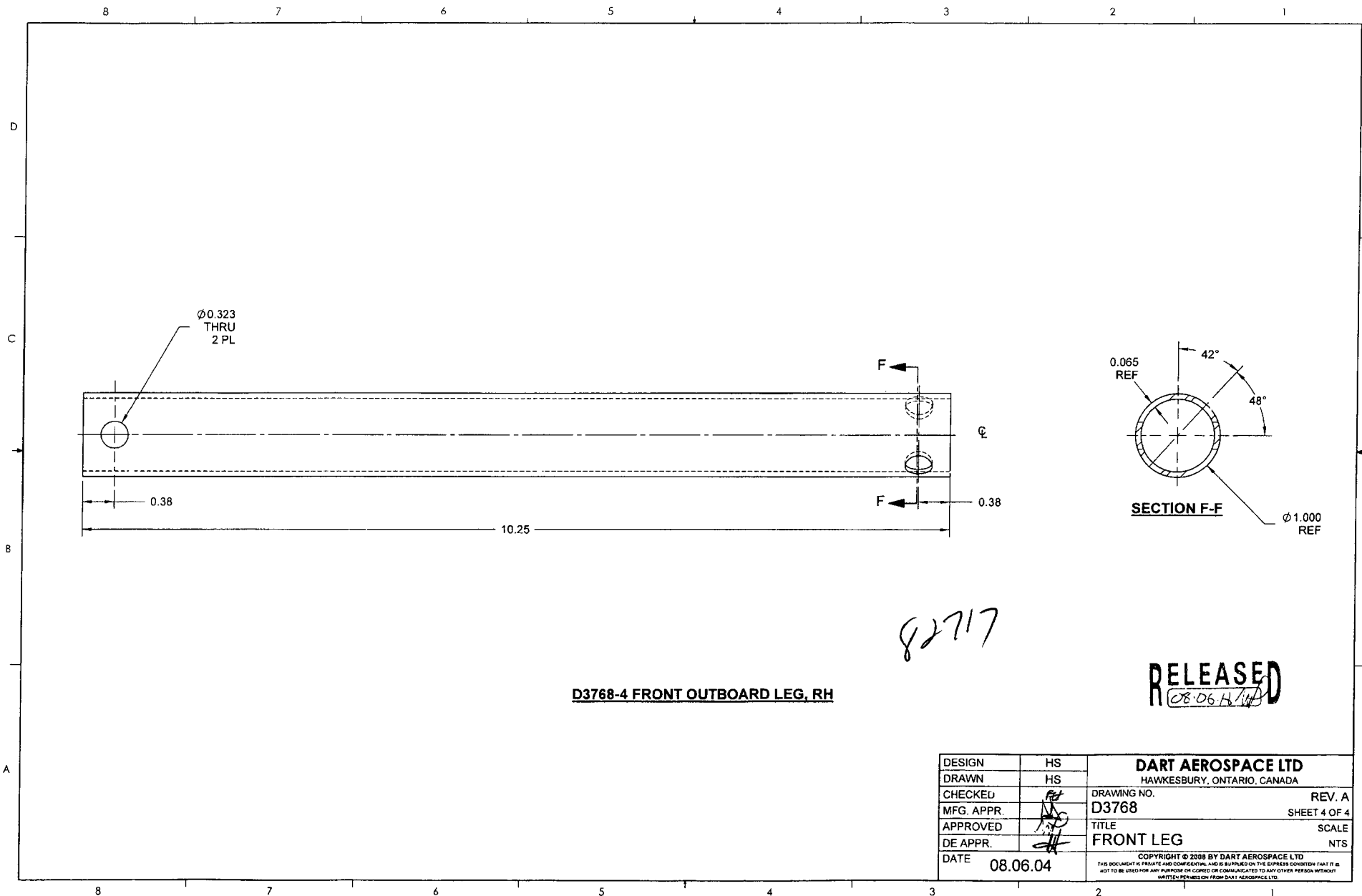
Dart Aerospace Ltd

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